Work Order ID 66553

Tuesday, February 22, 2011 9:18:29 AM

Item ID: D3283-1 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Doubler

Start Date: 2/22/2011 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 2/25/2011 **Req'd Qty:** 20.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** 11-02-22 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3283	Rev E								
100		0.00							
Waterjet	FLOW WATER JET					KB 11-2-24			
	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3283 ☐Dwg Rev: E ☐Prog Rev: E ☐2-								
6061-0052	Deburr if necessary							69	
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC						KB 11-2-24			
	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				counted			
QC		Sil 02/28				x29			
	Memo	0.00							
Quality Control									

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 66553

Tuesday, February 22, 2011 9:18:29 AM

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Revision ID: **Stop**

Item Name: Doubler

Start Date: 2/22/2011 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 2/25/2011 **Req'd Qty:** 20.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
Small Fab	**Memo**	0.00							
Small Fab	Debur n/a								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00 n/a							
Quality Control	******ensure rivet fits in #30 (0.128") holes as per dwg *******								
150	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	**Memo**	0.00							
Hand Finishing									

8

=7 MF 11/02/28

2ax

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

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Work Order ID 66553

Tuesday, February 22, 2011 9:18:29 AM

Item ID: D3283-1 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Doubler

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Required Date: 2/25/2011 **Req'd Qty:** 20.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				29.	BR	11-2-28.	
QC	**Memo**	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: Cyl	0.00				11/3/01	(29		
Packaging	**Memo**	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00				11/03/01			
QC	**Memo**	0.00							
Quality Control						CL 11/03/01			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Tuesday, February 22, 2011 9:18:36 AM

Work Order ID: 66553

Parent Item: D3283-1

Parent Item Name: Doubler

Start Date: 2/22/2011 **Required Date:** 2/25/2011

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP □A□04.09.28□New issue□KJ/JLM□
IPP Rev:B Now on Waterjet 07-05-28 JLM
IPP Rev:C As per Rev E 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	157.5000	0.2361	4.970526	7.		

RB 11-2-24

Location		Loc Qty	Loc Code
MAT		123.6	
	116308	35.6	
	116623	88	
MAT21		33.9	
	113608	33.9	

116308

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	66553
Description: Doubler	Part Number:	D3283-1
Inspection Dwg: D3283 **Rev:** E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.750	+/-0.010	14.750	✓		T HB01	
10.634	+/-0.010	10.627	✓		T	
1.250	+/-0.010	1.247	✓		V HB02	
1.250	+/-0.010	1.250	✓		V	
1.500	+/-0.010	1.498	✓		V	
3.000	+/-0.010	2.998	✓		V	
1.170	+/-0.010	1.175	✓		V	
0.710	+/-0.010	.711	✓		V	
0.250	+/-0.010	.250	✓		V	
1.420	+/-0.010	1.424	✓		V	
Ø0.500	+0.006/-0.001	.501	✓		V	
Ø0.129	+0.005/-0.001	.132	✓		V	

Measured by:	HB	Audited by:	D	Prototype Approval:	N/A
Date:	11-2-24	Date:	11/02/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.23	New Issue	KJ/JLM	
B	07.06.04	Dimensions updated per Dwg Rev. D	KJ/JLM	
C	07.09.26	Dwg Rev updated	KJ/EC	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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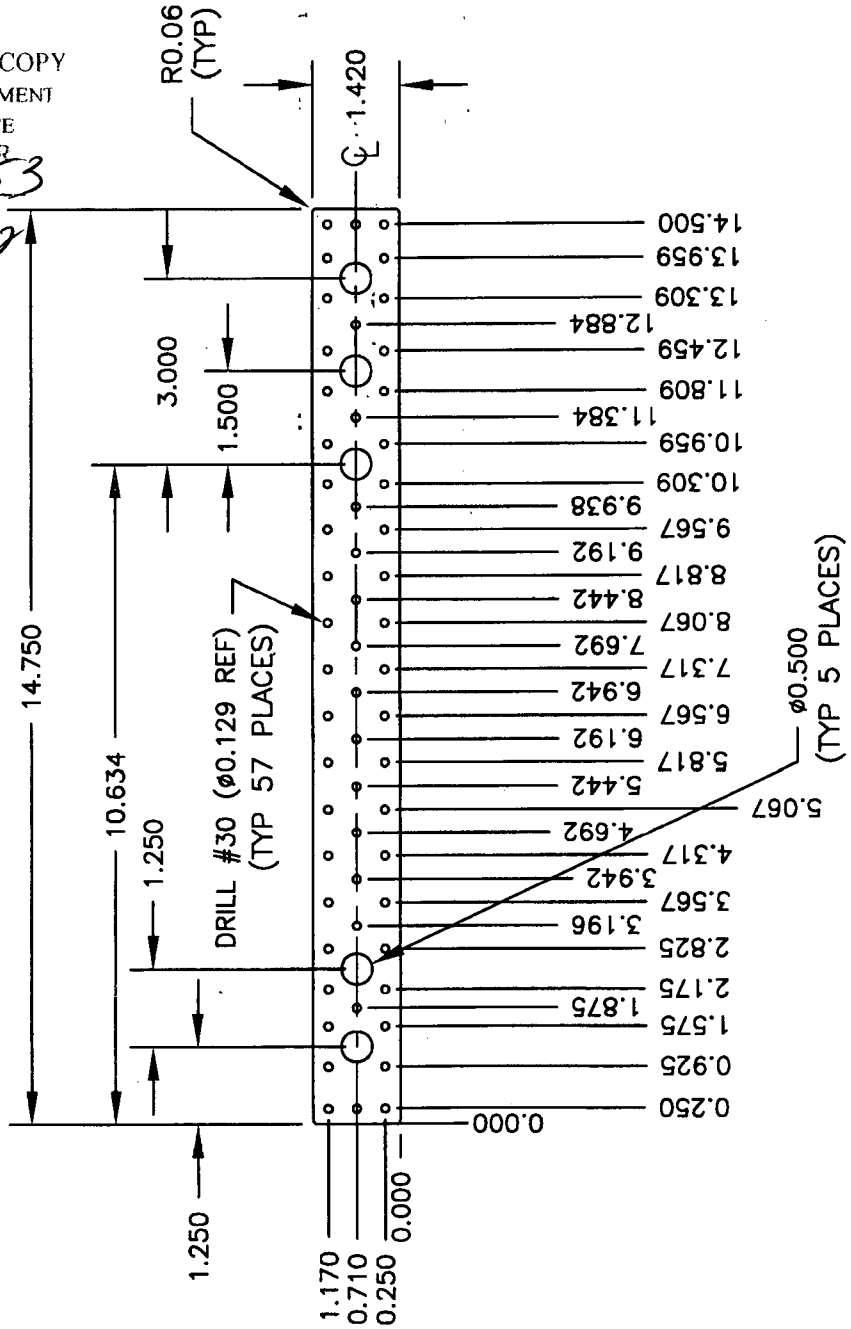
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3283	REV. E SHEET 1 OF 2
DATE 07.06.01		TITLE DOUBLER	SCALE 1:3

A	04.05.06	NEW ISSUE
B	04.08.09	10.882 WAS 11.502
C	05.03.16	CHANGE HOLE PATTERN FOR −1
D	05.08.09	REDESIGN
E	07.06.01	MISSING HOLE ADDED @ (7.692, 0.710)

RELEASED 07.08.29 PH PER ECN 959

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66553
pl 11-02-22



D3283-1 DOUBLER

1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

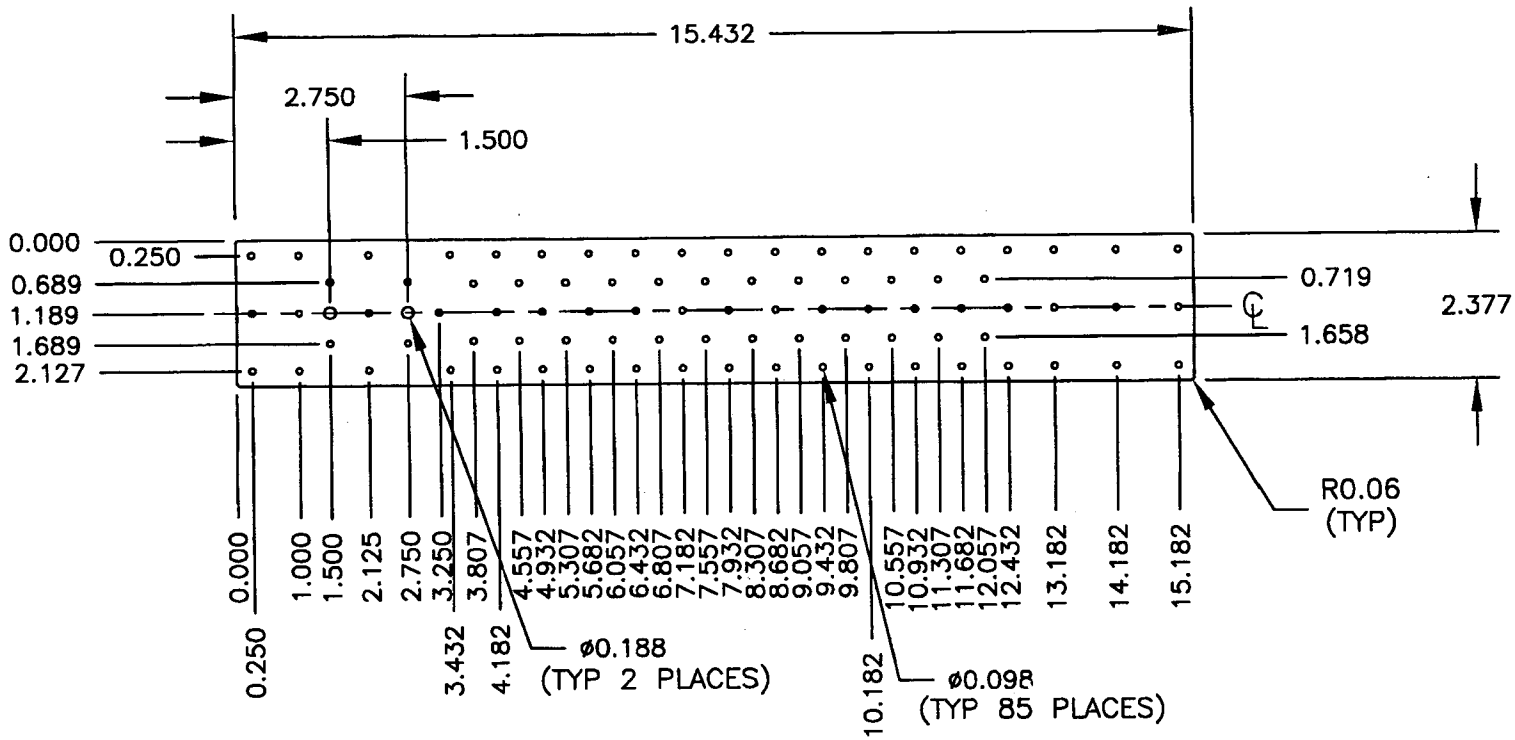
NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3283	REV. E
DATE 07.06.01		TITLE DOUBLER	SHEET 2 OF 2
			SCALE 1:3

w/o 66553

RELEASED 07 08 29 AW PER ECN 969



D3283-3 DOUBLER

1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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